

Work Order ID 122733

Tuesday, July 22, 2014 8:44:57 AM

122733

Page 1

Item ID: D3608-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lower Doubler

Start Date: 7/21/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/21/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLD

Date: 14-07-23

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3608	C

100

100

Waterjet

FLOW WATER JET

0.00

(4)

De 14/07/08

DAS

23

9-89

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3608

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

(4)

De 14/07/08

DAS

23

9-89

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

(4)

DAS

38

9-89

14-9-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	Bending <input type="checkbox"/>	General	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced Set-up <input type="checkbox"/>
	Centre Not Concentric <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
	Cracks <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
	Cuffs <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Other <input type="checkbox"/>
	Crushing <input type="checkbox"/>	Contamination <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
	Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
	Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>		
	Marks/Chatter <input type="checkbox"/>	Drawing <input type="checkbox"/>	Off-set <input type="checkbox"/>		
	Turning Sequence <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
	Wave/Twist in Tube <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		
		Fit/Function <input type="checkbox"/>			

Work Order ID 122733

Tuesday, July 22, 2014 8:44:57 AM

122733

Page 2

Item ID: D3608-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lower Doubler

Stop

NS2

Start Date: 7/21/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/21/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: ST505

0.00

DAS

28

0.00

SEP 11 2014

150

Packaging

Packaging

Memo

0.00

4X

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.00

14/9/12 JJ

JMF

14-9-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____		DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____		Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
		Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
		Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre	1/1	1/2								
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										
FAULT CATEGORY										
Landing Gear			General							
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced						
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up						
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure						
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld						
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled						
Crushing	Countersink	Misaligned/off center	Positioned Wrong							
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other						
Inspection Strip in Tube	Drawing	Misread								
Marks/Chatter	Drill Holes	Off-set								
Turning Sequence	Finish	Out of Calibration								
Wave/Twist in Tube	Fit/Function	Out of Sequence								

Picklist Print

Page 1

Tuesday, July 22, 2014 8:44:56 AM

Work Order ID: 122733

122733
D3608-1

Parent Item: D3608-1

Parent Item Name: Lower Doubler

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-03-26 JLM

IPP Rev:B 08-10-15 preliminary issue DD verified by:EC

IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP

Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E

10.11.17 as per PC1 dwg DD verified by:EC IPP Rev:F 10.11.29 as
per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	315.2519	0.7392	3.112421			DAS 23 9-89

M304S20GA

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	315.2518948	
m126852	0.31	
m127454	26.1018948	
m128435	119.14	
m129128	6.5	
m129530	19.2	
m129845	144	3.3

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>	DISPOSITION <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved	AGAINST DEPARTMENT/PROCESS <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <table style="width: 100%; border-collapse: collapse;"> <tr><td style="width: 20%;"><input type="checkbox"/> Bend</td><td style="width: 20%;"><input type="checkbox"/> Folio/Program</td></tr> <tr><td><input type="checkbox"/> BOM/Route</td><td><input type="checkbox"/> Grain</td></tr> <tr><td><input type="checkbox"/> Broken/Damage/Defect</td><td><input type="checkbox"/> Hardware</td></tr> <tr><td><input type="checkbox"/> Burrs</td><td><input type="checkbox"/> Inspection Incomplete/Unqualified</td></tr> <tr><td><input type="checkbox"/> Contamination</td><td><input type="checkbox"/> Instructions Incomplete/Unclear</td></tr> <tr><td><input type="checkbox"/> Countersink</td><td><input type="checkbox"/> Misaligned/off center</td></tr> <tr><td><input type="checkbox"/> Cut Too Short</td><td><input type="checkbox"/> Mislabeled</td></tr> <tr><td><input type="checkbox"/> Drawing</td><td><input type="checkbox"/> Misread</td></tr> <tr><td><input type="checkbox"/> Drill Holes</td><td><input type="checkbox"/> Off-set</td></tr> <tr><td><input type="checkbox"/> Finish</td><td><input type="checkbox"/> Out of Calibration</td></tr> <tr><td><input type="checkbox"/> Fit/Function</td><td><input type="checkbox"/> Out of Sequence</td></tr> </table>										<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program																															
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<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other																															
<input type="checkbox"/> Power Loss/Surge																																

DART AEROSPACE LTD	Work Order:	122733
Description: Lower Doubler	Part Number:	D3608-1
Inspection Dwg: D3608	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	23 9-89	Audited by:	38 9-89	Preliminary Approval:	
Date:	14/09/08	Date:	14-9-08	Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	10.02.18	Dimensions updated per Dwg Rev B	KJ	
C	10.12.21	Dimensions updated per Dwg Rev C	KJ	



